



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3110

Job Sheet 185759



✓
LOAD

Part No: 646.3110

Job Qty: 10 ea

Part Name: Channel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/1/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3100 REV N/C IPP REV:A NEW ISSUE 12-10-24 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	10 pcs	11/23/18	11/23/18	0.00	0.55	Bandsaw1		
110	CNC Vertical Machining	10 pcs	11/23/18	11/23/18	0.43	11.11	HAAS1-1		
120	QC	10 pcs	11/23/18	11/23/18	0.00	0.00	QC2 Machining-1		
130	QC	10 pcs	11/23/18	11/23/18	0.00	0.00	QC8 Machining-1		
140	Outsource	10 pcs	11/23/18	11/23/18			ATG001-VC	8	
150	Packaging	10 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		
155	QC	10 pcs	11/23/18	11/23/18	0.00	0.00	QC5		
180	Packaging	10 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-1		
190	QC21-SA	10 Ea	11/23/18	11/23/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 15.00"

Descriptions: 110 - 1-Machine per folio FB145

140 - Issue P/O to ATG : 20042031 - Hard Anodize Black and Prime as per Dwg 646.3100

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.500X1.500	7075-T6S Sheet 1.5" Thick Plate X 1.5" Wide	12.5000 ft (1.25 ea)	90-Start up Operation	

1.000X1.250
(1.000X1.250)

6x → 3.104631
+ 4x → F123218

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.500X1.500	13	4	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Channel	14.600inches ± 0.010	14.610 14.590		
2	Channel	13.130inches ± 0.010	13.140 13.120		
3	Channel	0.090inches ± 0.010	0.100 0.080		
4	Channel	0.470inches ± 0.010	0.480		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																		
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			0.460	
5	Channel	0.750inches ± 0.010	0.760 0.740	
6	Channel	83.000Degrees ± 0.500	83.500 82.500	Angle
7	Channel	0.880inches ± 0.010	0.890 0.870	
8	Channel	0.645inches ± 0.005	0.650 0.640	
9	Channel	0.110inches ± 0.010	0.120 0.100	
10	Channel	0.120inches ± 0.010	0.130 0.110	
11	Channel	0.209inches + 0.005 - 0.001	0.214 0.208	Diameter
12	Channel	0.409inches ± 0.005	0.414 0.404	
13	Channel	0.420inches ± 0.002	0.422 0.418	
14	Channel	2.188inches ± 0.002	2.190 2.186	
15	Channel	2.188inches ± 0.002	2.190 2.186	
16	Channel	2.188inches ± 0.002	2.190 2.186	
17	Channel	2.187inches ± 0.002	2.189 2.185	
18	Channel	0.785inches ± 0.002	0.787 0.783	
19	Channel	2.395inches ± 0.002	2.397 2.393	
20	Channel	0.669inches ± 0.002	0.671 0.667	
21	Channel	0.372inches ± 0.002	0.374 0.370	
22	Channel	0.334inches ± 0.002	0.336 0.332	
23	Channel	0.175inches ± 0.002	0.177 0.173	
24	Channel	0.130inches ± 0.002	0.132 0.128	

Plex 11/1/18 1:53 PM Dart.laieunesse.marie

DART
AEROSPACE

Container No: **S136495**

Part: **646.3110**

Job No: **185759**

Serial No/Batch: **S136495**

Revision:
Inspector:
Exp Date:
Instructions:



UAT Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6H 1K7
CANADA
TEL: 1 513 632-5200
Email: sales@dartco.com
www.dartco.com

Date: 12/10/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042031**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO042031
PO Date: 12/12/18
Due Date: 12/21/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Attention: Lalande, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	187615	647.7820	Cross Bracket Aft Outsource process- Anodize per QSI017 4.1.10.1 Issue P/O TO ATG: Anodize & prime as per Dwg. 647.7800	Firmed	-	12/21/18	4 pcs	0 pcs	4 pcs	\$24.56/pcs	\$98.24
2	185759	646.3110	Channel Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3100	Firmed	-	12/21/18	10 pcs	0 pcs	10 pcs	\$24.56/pcs	\$245.60
3	185451	RBE105- 31781W2- 3	Base -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR CLEAR, PER IAW MIL-A- 8625F TYPE 2 CLASS 1, Water sealant -Material type: 6061T6 -Certificate of Conformity is required	Firmed	-	12/21/18	8 pcs	0 pcs	8 pcs	\$11.35/pcs	\$90.80

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Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER

PO042031

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:											\$434.64

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916875

Date: 19-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 4 ea	Part: 647.7820 Cross Bracket Aft Outsource process - Anodize per QSI017 4.1.10.1 Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24348	Rev: A	PO: PO042031 ✓ Line: 1
✓ 10 ea	Part: 646.3110 ✓ Channel Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24349	Rev: NC	PO: PO042031 ✓ Line: 2
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>DEC 19 2018</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			